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RBE1X36-176-779
Job Sheet 200532



Part No: RBE1X36-176-779

Job Qty: 1 pcs

Part Name: Spanner



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/12/19

Job Tracking No:

Due Date: 9/30/19

Created By: Marie Lajeunesse

Type: SOLD

Description: ORDER 19481

Note: DWG RBE1X36-176-779 Rev. D IPP Rev. A 18.08.23 New issue DP Verify DD/IPP Rev. B 19.05.02 drawing revision DP Verify DD/IPP Rev. C 19.06.06 Material change DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	9/30/19		0.08	0.05	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
110	QC 5	1 pcs	9/30/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	1 pcs	9/30/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		



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Container No: S213947



Part: RBE1X36-176-779

Job No: 200532

Serial No/Batch: S213947

Revision: D

Inspector:

Exp Date:

Instructions:

Date: 09/16/19

Plex 9/12/19 10:32 AM Dart.lajeunesse.marie

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

Packaging 3 - 34 - B4B

Packaging 3 - 35 - B4B

Packaging 3 - 36 - B4B

DAS
28
9-89

140 QC 21 - FG

1 pcs

9/30/19

0.00 0.00

QC 21 - FG - 21

QC 21 - FG - 70

QC 21 - SA - 53

DAS
21
9-89

SEP 17 2019

Part Op 100 - (Small Fab) Assemble as per drawing. See note 8.

Descriptions: 110 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: _____) 1-The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
92905A114	Set Screw, M5 x 0.8mm Thread, 8mm long	1 Ea (1 ea)	100-Small Fab - 1	
RBE1X36-176-779-1	Sleeve	1 pcs (1 ea)	100-Small Fab - 1	5105-598
RBE1X36-176-779-2	Driver	1 pcs (1 ea)	100-Small Fab - 1	5188952
				5182825

Job Allocations

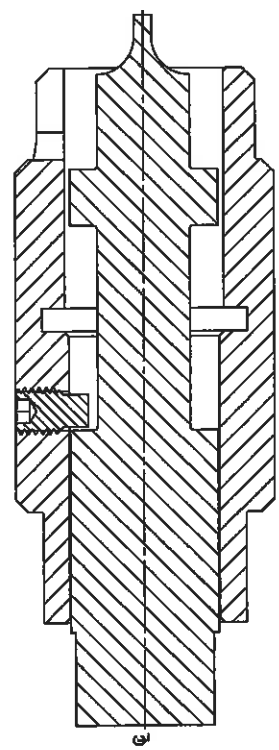
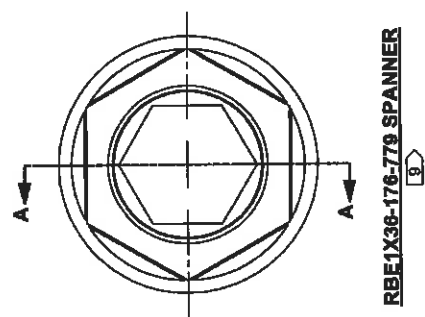
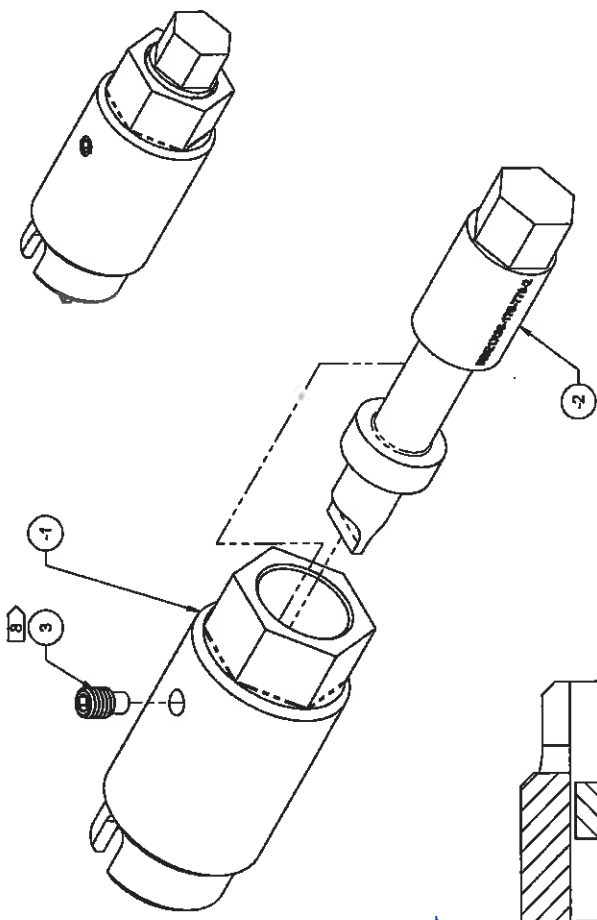
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	92905A114	1	97	0
	RBE1X36-176-779-1	1	1	0
	RBE1X36-176-779-2	1	8	0

Part Specifications

Specifications could not be found.

ITEM #	QTY	PART #	PART TITLE
-1	1	RBE1X38-176-779-1	SLEEVE
-2	1	RBE1X38-176-779-2	DRIVER
3	1	McMaster#2905A114 OR EQUIV	STEEL EXTENDED-TIP SET SCREW M6 X 0.8mm X 8mm LG.

SHOP COPY
 RETURN TO
 ENGINEER
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 200532 HWS
 19-09-12



D	MATERIAL H13 CHANGED FOR 01	19.762	VM
C	SEE PREVIOUS RBE FOR OLDER REV'S TEMPLATE UPDATED PER DART HAWKESBURY STANDARDS ITEM -1 MATERIAL 4140M4142 RC 44-48 CHANGED FOR H13 RC 48-52 MIN RELIEF ADDED. R0.008 MAX 7 PL ADDED. ENGRAVING SN AND MADE IN USA REMOVED. DIMENSION 2.40 CHANGED FOR 0.840 +.004 -0.002. DIMENSION 3.80 CHANGED FOR 0.380 +.004 -0.002. DIMENSION 3.97 CHANGED FOR 0.47 +.004 -0.002. DIMENSION 0.02 X 45.00 CHANGED FOR 0.02 X 45.00. DIMENSION 0.02 X 45.00 CHANGED FOR 0.02 X 45.00 ITEM -2 FINISH BLACK OXIDE CHANGED FOR ZINC PLATE TYPE 2. DIMENSION 2.90 CHANGED FOR 0.80 +.002 -0.002. DIMENSION R.015 CHANGED FOR R.015. DIMENSION 3.80 CHANGED FOR 0.380 +.004 -0.002 DIMENSION 3.88 CHANGED FOR 3.038 REF. ADDED 0.25 2 PL DIM		VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM		
CHECKED	VM		
MFG. APPR.	KPT		
APPROVED	JFC		
DATE	2019-06-07		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA TOOL PART # RBE1X38-176-779 TITLE SPANNER REV. D SHEET 1 OF 3 SCALE NTS CDR: 19-06-07 BY DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA THIS TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG			

- NOTES:
 1) MATERIAL: N/A
 2) HEAT TREAT: N/A
 3) FINISH: N/A
 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
 X.XX = +/- 0.01" / +/- 0.5"
 X.XXX = +/- 0.005" / +/- 0.1"
 X.XXXX = +/- 0.0005" / +/- 0.05"
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 UNLESS OTHERWISE NOTED
 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 6) IDENTIFICATION: N/A
 7) ASSEMBLY AS SHOWN
 8) ASSEMBLY ITEM 3 SO ITEM -2 ROTATES AND SLIDES FREELY
 9) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QSI042) _____	
Description Work Order Deviation		Disposition			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____	Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐	Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐
		Completed By _____			
		Lead hand / Supervisor _____			
		QC / QA Coordinator _____			